Dart Aerospace Ltd. Thursday, 8/30/2007 3:51:19 PM Date: User: Kim Johnston **Process Sheet** : CLAMP Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number Estimate Number : 11966 Part Number : D2055 P.O. Number : 8/30/2007 S.O. No. : **Drawing Number** · D2055 C1 This Issue : N/A : NC Prsht Rev. Project Number First Issue : // Type : RMA : C1 **Drawing Revision** : 28823 Material Previous Run Due Date : 9/30/2007 100 Um: Each Written By Checked & Approved By Comment : Est. 02.03.07 NG Now turned in house **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M6061T6R1000 ROUND BAR 1.00" 1.0 Comment: Qty.: Total: 10.9410 f(s) 0.1094 f(s)/Unit ROUND BAR 1.00" Material: 6061-T6 rod (QQA-A-225/8) 2.0 HARDINGE Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA203 Tumble & deburr all sharp edges as per dwg 3.0 ₽¥QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK Comment: SECOND CHECK MILLING CONV CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per dwg D2055

INSPECT WORK TO CURRENT STEP

J.F. 08/0,

Comment: INSPECT WORK TO CURRENT STEP

J.F. 08/0/27



W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		•								
, or										

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	D Date: <u>08102/04</u>
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			A ======	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
08/01/28 5		Ipart is scrap, I drill the hole thru R.C. Humman eman	Borjin	Scarp and Destry	J.F. 08/01/28	5	02012	5		
		R.C. Humman enal		QL/RI)	08/01/28	odales		OSTOPLES		
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NOTE: Date & initial all entries

	Thursday, 8/30/2007 3:51:19 PM Kim Johnston	B 01 1		
		Process Sheet		
Custon	ner: CU-DAR001 Dart Helicopters S	ervices Drawing Name: CLAM	P	
Ioh Numi	ber: 34365	Part Number: D2055	ξ	
Job Number:		Fait Nulliper, Second		
000 114				
Seq. #:	Machine Or Operation:	Descriptio	on :	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	1100111011000110011100111001	
				counted/
Cor	mment: HAND FINISHING RESOL		-	ا د د د د د د د د د د د د د د د د د د د
	Acid etch and Alodine as p		-01-28	X99
8.0	POWDER COATING	POWDER COATING		
		M100700		
Cor	mment: POWDER COATING	W/D ( 40 57) 001005 40	- 00	
9.0	QC3	x (Ref: 4.3.5.7) as per QSI 005 4.3  INSPECT POWDER COAT/CHEMICAL	CONVERSION	31 (18)
5.0		INGLEST CONSELLATIONS		
and the state of t				
	mment: INSPECT POWDER COA		3/02/01 (X59)	
10.0	PACKAGING 1	PACKAGING RESOURCE #1	1 1881	
Con	mment: PACKAGING RESOURCE	#1		
·	Identify and Stock Location: 57	$\mathcal{A}$	9/02/01	X99
11.0	QC21	FINAL INSPECTION/W/O RELEASE	7 7	
				(99)
Con	mment: FINAL INSPECTION/W/O	RELEASE	130101111111111111111111111111111111111	20/60/80
	THAL HOLLOHOLOHAWA			77
Job Completion		mi 2008/	2/04 (99	
	(100)			
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Dart Ae	rospace L	td w		14						
W/O:		n	WC	ORK ORDER CHA	ANGES	я	<del></del>			· · · · · · · · · · · · · · · · · · ·
DATE STEP		PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								<u> </u>		
Part No		PAR #:	Fault Cate	gory:	NC	R: Yes I	No DQ	A:	_ Date: _	
						QA: N/	C Close	d:	_ Date: _	
NCR:			WORK ORDI	ER NON-CONFO	RMANCE	(NCR	)			
DATE	oren	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign & Date	Secti		Chief Eng	QC Inspector
									×	
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		4.								
	f			8						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 34365	<u> </u>
	·	<i>:</i>
Description: CLAMP	Part Number: D2055	
	Page 1	of 1
Inspection Dwg: D2055 C1 Rev: C1	raye i	<u> </u>

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/010	1.000	1			
0.090	+/010	0.090	<b>V</b>			
0.063	+/010	0.063	<b>✓</b>			
0.D 0.750	1/010	ø.752	<b>✓</b>			
0.625 00	0.625/0.623	0.624	<b>✓</b>			
0.513	0.513/0.518	Ø.515	<b>✓</b>	3-1		
1.000	+/010	0.9970	<b>/</b>			
-						
0.300	+/010	305	/			CNC MILL
Ø 0. 19 1	+.005	190				ENC MILL
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	4					
Measured by:	M.A.		Audited by:	1.F	Prototype Approval:	
Date:	08/0	1/25	Date:	08/01/28	Date:	

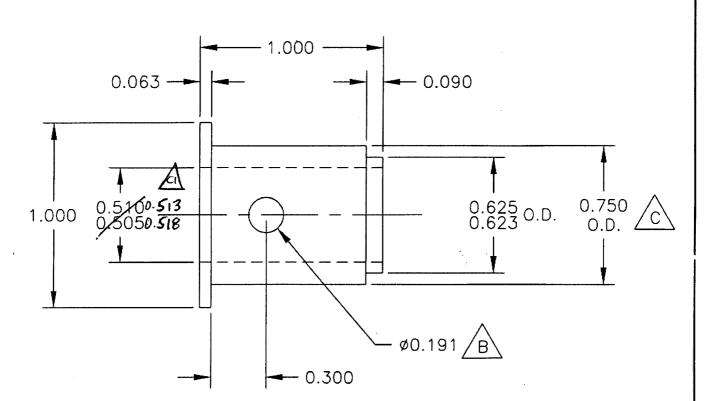
	Rev	Date	Change	Revised by	/ Approved
	^	Duto		KJ/RF	
- 1	Α .		New Issue		





	DESIG	N JB	DRAWN BY	DART AEROSPACE LTD
		UD.	1 CT	HAWKESBURY, ONTARIO, CANADA
	CHEC	KEP/	APPROVED	DRAWING NO. REV. C
		At	- <del>   </del>	D2055 SHEET 1 OF 1
	DATE			TITLE SCALE
	98.1	12.10	•	CLAMP 2:1
	Α		92.03.13	NEW ISSUE
	В	7	98.10.15	0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH
1	U		98.12.10	ADDED 0.750 O.D. DIMENSION
	CI	41	01.06.05	MODIFY HOLE SIZE, ADD P/C OPTION

RELEASED



ACID ETCH 4 ALODINE PER
DART OST OS 4.1
POUNER CONFT BLACK SAMMIEX (4.15.7)
PER DART Q SHOBOL 43
RETURN TO

MATERIAL: 6061-T6 ROD (QQ-A-225/8)

FINISH: BLACK ANODIZE OR -

BREAK ALL SHARP EDGES 0.015 MAX.

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTE

ENGINEERING
UNCONTROLLED COPY

UNCONTROLLED

ONE OF THE OWNER

ON THE OWNER

WORK ORDER 5